

Work Order ID 122778

Thursday, July 24, 2014 12:58:38 PM

122778

Page 1

Item ID: 646.9701

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Cutter Sub Assembly

Start Date: 7/25/14 Start Qty: 16.00

16

Cust Item ID:

Required Date: 7/25/14 Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: *JA*

Date: *14-7-24*

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

646.9700

C

105

QC6- Inspect dimensions to drawing

0.00

EB
14/07/24

DAS
27
9-89

16

105

QC

Quality Control

Memo

PULL FROM STOCK

647.9701 X16
B121354

MIS-IDENTIFIED SHOULD BE
646.9701

115

0.00

115

Packaging

Packaging

Memo

RE-PACKAGE USING NEW
BATCH NUMBER

0.00

cch-11

DAS
32
9-89

14/7/20 *1c*

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
|--|--|---|

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Work Order ID 122778

Thursday, July 24, 2014 12:58:38 PM

122778

Page 2

Item ID: 646.9701

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cutter Sub Assembly

Stop ***NS2***

Start Date: 7/25/14

Start Qty: 16.00

16

Cust Item ID:

Required Date: 7/25/14

Req'd Qty: 16.00

16

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC21 - Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MLJ 14-07-25
MLJ 14-07-25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | |
|--|--|---|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <div style="display: flex; justify-content: space-between;"> <div> Skid-tube <input type="checkbox"/> Machining <input type="checkbox"/> Thermoforming <input type="checkbox"/> Large Fab <input type="checkbox"/> </div> <div> Crosstube <input type="checkbox"/> Small Fab <input type="checkbox"/> Finishing <input type="checkbox"/> Composite <input type="checkbox"/> </div> <div> Water Jet <input type="checkbox"/> Prod. Eng. Coord. <input type="checkbox"/> Rec/Store/Packaging <input type="checkbox"/> Supplier <input type="checkbox"/> </div> <div> Engineering <input type="checkbox"/> Quality <input type="checkbox"/> Other <input type="checkbox"/> </div> </div> |
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| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
| Landing Gear <input type="checkbox"/> Bending <input type="checkbox"/> Centre Not Concentric <input type="checkbox"/> Cracks <input type="checkbox"/> Crimp/Kink/Ripple/Wave <input type="checkbox"/> Cuffs <input type="checkbox"/> Crushing <input type="checkbox"/> Heat Treat <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Marks/Chatter <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube | General <input type="checkbox"/> Bend <input type="checkbox"/> BOM/Route <input type="checkbox"/> Broken/Damage/Defect <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Countersink <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Drawing <input type="checkbox"/> Drill Holes <input type="checkbox"/> Finish <input type="checkbox"/> Fit/Function | <input type="checkbox"/> Folio/Program <input type="checkbox"/> Grain <input type="checkbox"/> Hardware <input type="checkbox"/> Inspection Incomplete/Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Misaligned/off center <input type="checkbox"/> Mislabeled <input type="checkbox"/> Misread <input type="checkbox"/> Off-set <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence | <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Incorrect <input type="checkbox"/> Part Lost/Missing <input type="checkbox"/> Part Moved <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Power Loss/Surge <input type="checkbox"/> Pressure/Forced <input type="checkbox"/> Set-up <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled <input type="checkbox"/> Other |
|--|--|---|--|

Picklist Print

Thursday, July 24, 2014 12:58:44 PM

Page 1

Work Order ID: 122778

122778

Parent Item: 646.9701

646.9701

Parent Item Name: Cutter Sub Assembly

Start Date: 7/25/14

Required Date: 7/25/14

Start Qty: 16.00

Required Qty: 16.00

Comments: IPP REV:A 12.08.13 NEW ISSUE DD VERF:JFS

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

647.9701

Manufactured

No

Each

4.0000

16

647.9701

Lower Cutter Sub Assembly

**

~~14-7-24~~

B 121354 X16

Location

Loc Qty

Loc Code

CCK48

4

m129311

4

646.9710

Manufactured

No

110

Each

56.0000

1

16

646.9710

Body

**

~~14-7-24~~

Location

Loc Qty

Loc Code

MF

56

106354

3

110623

4

116771

12

91439

1

94495

4

98917

11

98918

21

2

14

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

| | | | | | | | | | | | | | | | | | | |
|--|--|--|--------------------------------------|------------------------------------|------------------------------------|--------------------------------------|------------------------------------|------------------------------------|--|----------------------------------|--|------------------------------------|--|--------------------------------|------------------------------------|------------------------------------|-----------------------------------|--|
| Work Order: _____ Part No. _____ NCR No. _____ | DISPOSITION Rework <input type="checkbox"/> Scrap <input type="checkbox"/> Use-as-is <input type="checkbox"/> Suspected Unapproved <input type="checkbox"/> | AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube <input type="checkbox"/></td> <td>Crosstube <input type="checkbox"/></td> <td>Water Jet <input type="checkbox"/></td> <td>Engineering <input type="checkbox"/></td> </tr> <tr> <td>Machining <input type="checkbox"/></td> <td>Small Fab <input type="checkbox"/></td> <td>Prod. Eng. Coord. <input type="checkbox"/></td> <td>Quality <input type="checkbox"/></td> </tr> <tr> <td>Thermoforming <input type="checkbox"/></td> <td>Finishing <input type="checkbox"/></td> <td>Rec/Store/Packaging <input type="checkbox"/></td> <td>Other <input type="checkbox"/></td> </tr> <tr> <td>Large Fab <input type="checkbox"/></td> <td>Composite <input type="checkbox"/></td> <td>Supplier <input type="checkbox"/></td> <td></td> </tr> </table> | Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | |
| Skid-tube <input type="checkbox"/> | Crosstube <input type="checkbox"/> | Water Jet <input type="checkbox"/> | Engineering <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Machining <input type="checkbox"/> | Small Fab <input type="checkbox"/> | Prod. Eng. Coord. <input type="checkbox"/> | Quality <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Thermoforming <input type="checkbox"/> | Finishing <input type="checkbox"/> | Rec/Store/Packaging <input type="checkbox"/> | Other <input type="checkbox"/> | | | | | | | | | | | | | | | |
| Large Fab <input type="checkbox"/> | Composite <input type="checkbox"/> | Supplier <input type="checkbox"/> | | | | | | | | | | | | | | | | |

| Root Cause | Date | Step | Qty | Description of work order update or non-conformance | Initial Chief Eng | Action Description | Sign & Date | Verification | QC Inspector |
|---------------|------|------|-----|---|-------------------|--------------------|-------------|--------------|--------------|
| Design | | | | | | | | | |
| Doc/Data | | | | | | | | | |
| Equip/Tooling | | | | | | | | | |
| Handling/Pre | | | | | | | | | |
| Material | | | | | | | | | |
| Operator | | | | | | | | | |
| Offset/Setup | | | | | | | | | |
| Process | | | | | | | | | |
| Supplier | | | | | | | | | |
| Training | | | | | | | | | |
| Transport | | | | | | | | | |
| Unapproved | | | | | | | | | |

FAULT CATEGORY

| | | | |
|--|--|---|--|
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|--|--|---|--|

APICAL

INDUSTRIES, INC.

ENGINEERING CHANGE NOTICE NO. 04039

SHEET 1 OF 1

DWG NO. 646.9700

REV: B

PREPARED
BY

D. PETERS

DATE: 08/09/13

EFFECT ON DWG
☒ INC. ☐ UNINC.

DWG TITLE: CUTTER SUB ASSY

APPROVED BY:

ENGR

MFG

QC

EFF:

NEXT ORDER

TRANSACTION CODES (TC):
A-ADD C-CREATE
R-REVISE D-DELETE

REASON: MARKED INSPECTION DIMENSIONS

ECR:

NONE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 122378
14-7-24

DOCUMENTS EFFECTED:

☐ RFMS

☐ MDL

☐ INSTALL INSTRUC

☐ ICA

☐ BOM

CHANGE CATEGORY

☐ MAJOR ☒ MINOR

DER REVIEW REQUIRED

☐ YES

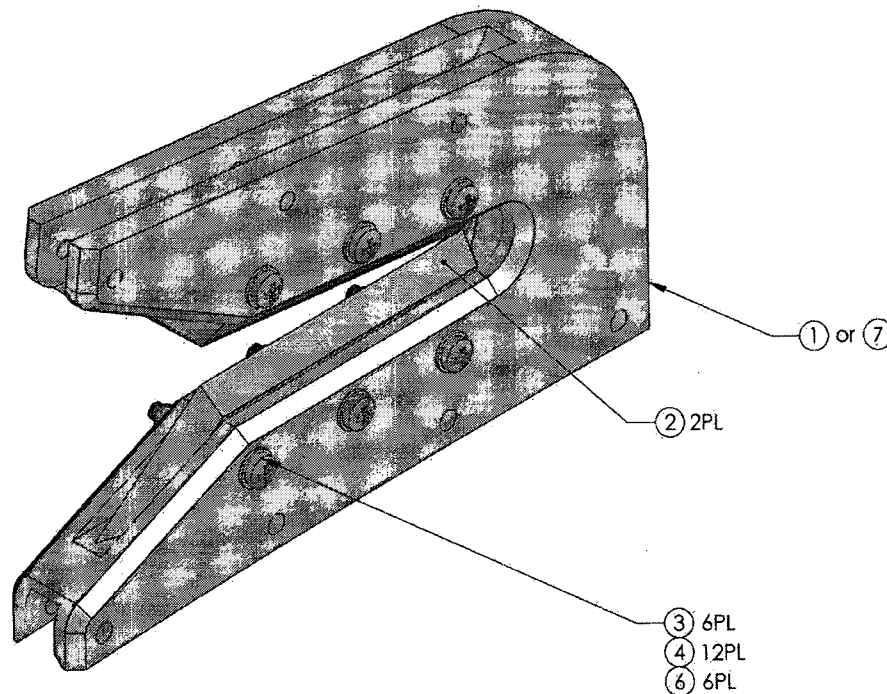
☒ NO

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| REVISIONS | | | |
|-----------|--------------------------------------|----------|----------|
| REV | DESCRIPTION | DATE | APPROVED |
| | LAST PROTOTYPE REVISION: PP2 | | N/C |
| N/C | INITIAL RELEASE | 05/29/09 | P. BRAYO |
| A | INCORPORATED EICH 02744 03030, 02912 | 06/04/13 | P. BRAYO |
| B | INCORPORATED EICH 03967 | 09/05/13 | P. BRAYO |
| C | INCORPORATED EICH 04029 | 06/07/13 | P. BRAYO |

NOTES:

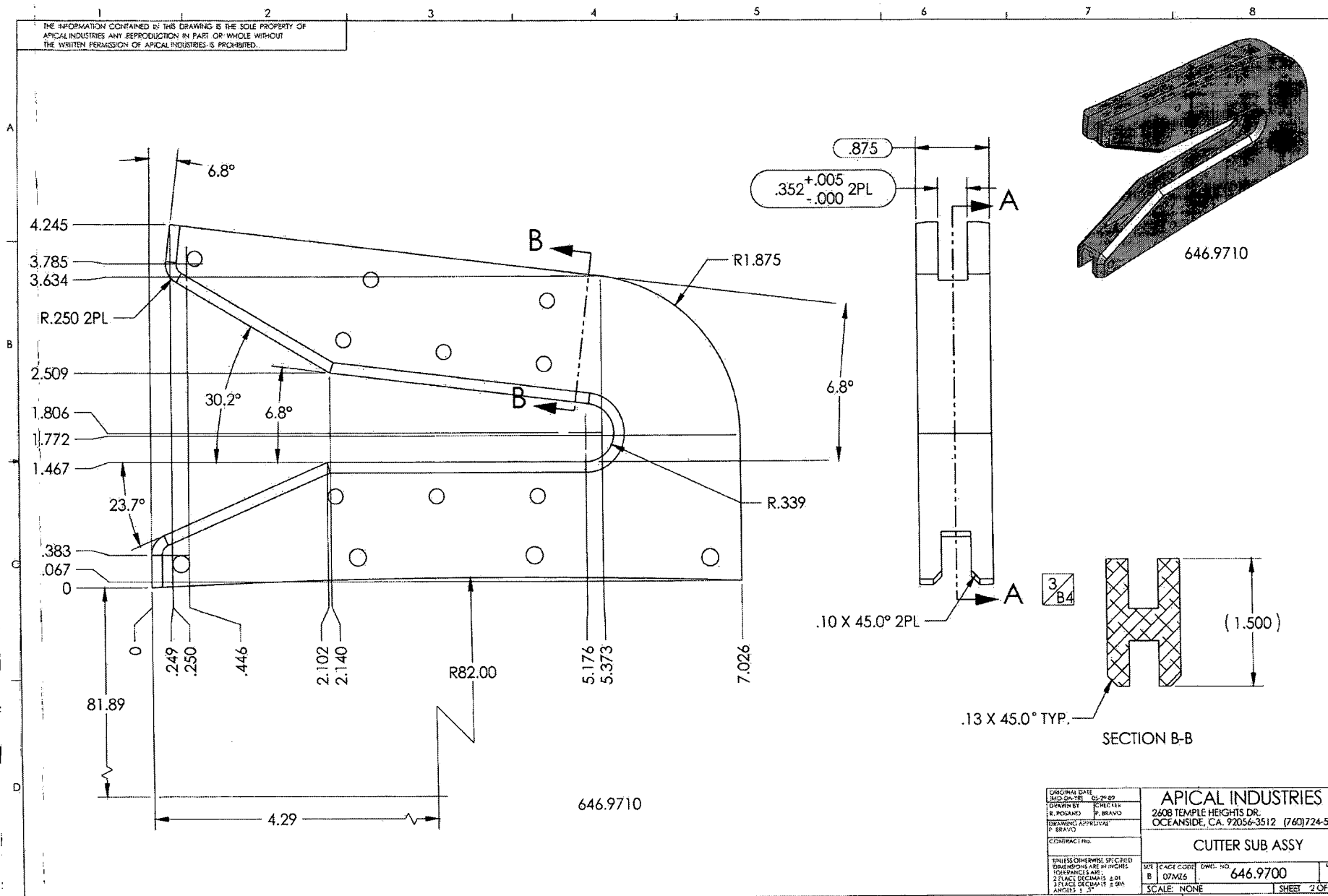
- 1 MATERIAL: ALUMINUM 7075-T651 PER AMS-QQ-A-250/12
- 2 FINISH: HARD ANODIZE IAW MIL-A-8625 TYPE III, CLASS 2, COLOR BLACK; PRETREAT PRC-DESOTO PR-148 ADHESION PROMOTER; PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 3 MATERIAL: AISI A2 TOOL STEEL
CONDITION: ANNEALED
POST PROCESS: HEAT TREAT TO 58-62 RC ROCKWELL HARDNESS
- 4 FINISH: PRIME IAW MIL-P-23377J TYPE I CLASS N; 1-2 MIL MAX
- 5 DEBURR AND BREAK ALL SHARP EDGES EXCEPT WHERE OTHERWISE NOTED
- 6 IDENTIFY IAW MPP-120
- 7 APPLY F/N 5 AS REQUIRED TO ALL FAYING SURFACES OF F/N 2 UPON ASSEMBLY
- 8 CUTTING EDGE INTENDED TO BE SHARP, DO NOT BREAK SHARP EDGE
- 9 ALL DIMENSIONS NOT SPECIFIED ARE CONTROLLED BY 646.9710.



646.9701
or
646.9702

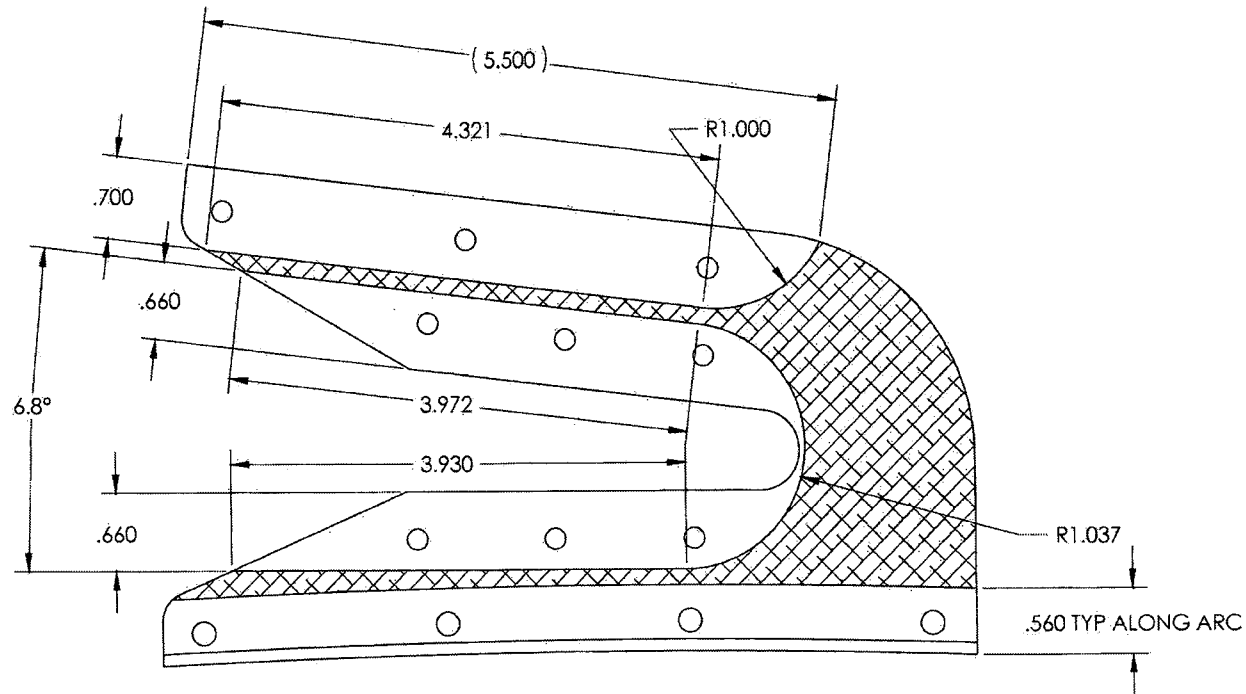
| 1 | 7 | 646.9712 | BODY (U CHANNEL) | △ | △/△ |
|---------------|--------|----------|--|--------------------|--------|
| 6 | 6 | 601.1541 | LOCKNUT | MS2-042108 | |
| A/R | A/R | 601.2764 | RTV, LOCTITE 598 | | |
| 12 | 12 | 601.2764 | WASHER | MS1149FMS37P | |
| 6 | 6 | 601.2765 | SCREW | MS27037-0819 | |
| 2 | 2 | 646.9711 | BLADE | △ | △ |
| 1 | 1 | 646.9710 | BODY | △ | △ |
| | | 646.9702 | CUTTER SUB ASSY (U CHANNEL) | | |
| | | 646.9701 | CUTTER SUB ASSY | | |
| QTY | FIND # | PART # | DESCRIPTION | MAT'L | SPEC. |
| PARTS LIST | | | | | |
| NEXT ASSY (S) | | | ORIGINAL DATE: 05/29/09 | | |
| 646.9600 | | | DRAWN BY: P. BRAYO | | |
| | | | DRAWING APPROVAL: P. BRAYO | | |
| | | | CONTRACT NO. | | |
| | | | UNLESS OTHERWISE SPECIFIED, DIMENSIONS ARE IN INCHES. TOLERANCES ARE: 2 PLACE DECIMALS ±.01; 3 PLACE DECIMALS ±.005; ANGLES ±.5° | | |
| | | | APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA 92056-3512 (760) 724-5300 | | |
| | | | CUTTER SUB ASSY | | |
| | | | SUB CASE CODE: 8 07M76 | FWC, FIG: 646.9700 | REV: C |
| | | | SCALE: NONE | | |
| | | | SHEET 1 OF 6 | | |

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| | | | |
|---|--|---|--------------|
| ORIGINAL DATE 3/10/2009 | | APICAL INDUSTRIES | |
| DRAWN BY R. POSEAND | | 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 | |
| DRAWING APPROVAL P. BRAVO | | CUTTER SUB ASSY | |
| CENTRICITY NO. | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ±.01 3 PLACE DECIMALS ±.005 ANGLES ±.5° | | SHEET NO. B | REV. C |
| | | SCALE: NONE | SHEET 2 OF 6 |

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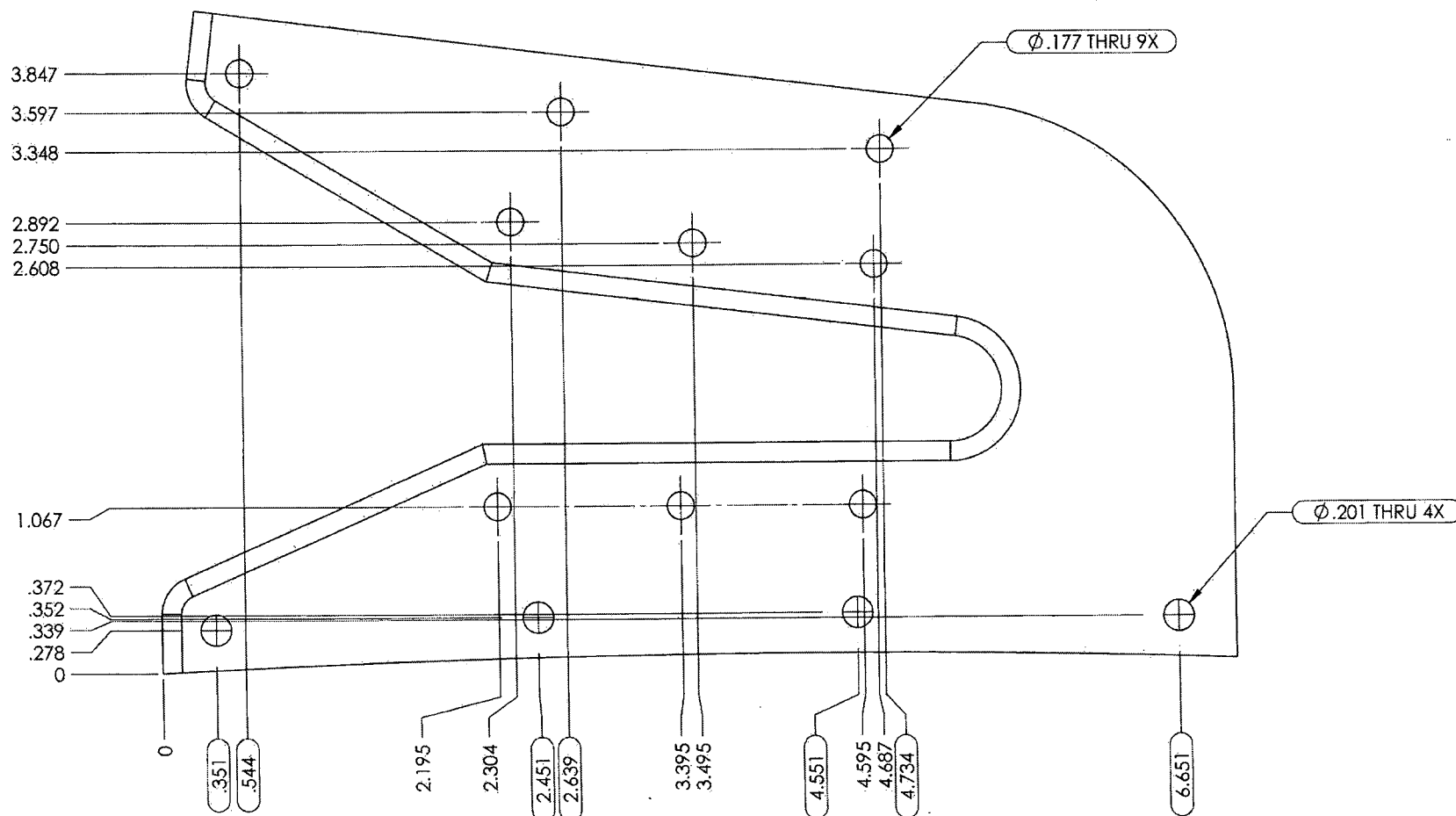


SECTION A-A

646.9710

| | | | |
|--|--|---|-----------------------------|
| OPTIONAL DATE AUG 24 1981 DRAWN BY R. ROSANO DRAWING APPROVAL P. ROSANO CONTRACT NO. | | APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES FRACTIONS ARE: 2 PLACE DECIMALS ± .01 ANGLES ± .5° | | SHEET B | DWG. NO. 646.9700 |
| SCALE NONE | | SHEET 3 OF 6 | |

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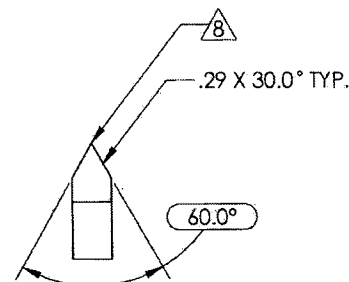
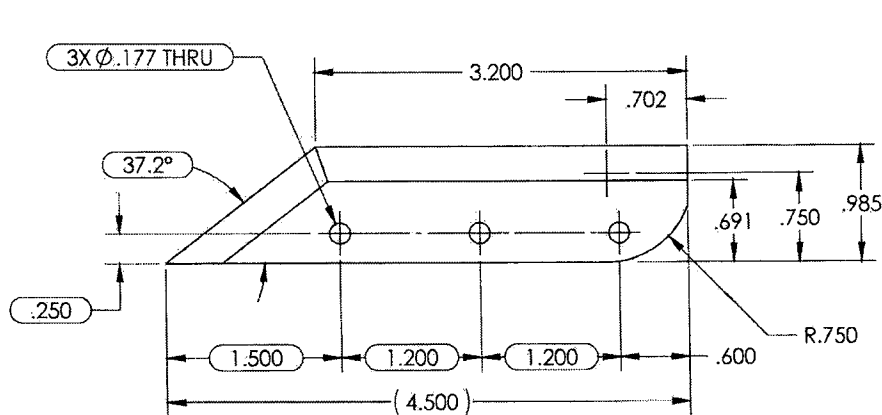
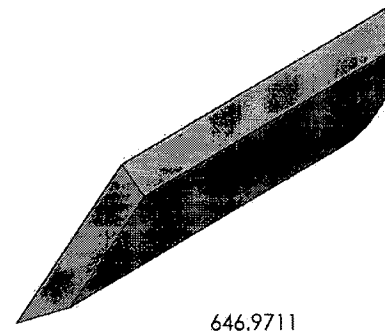
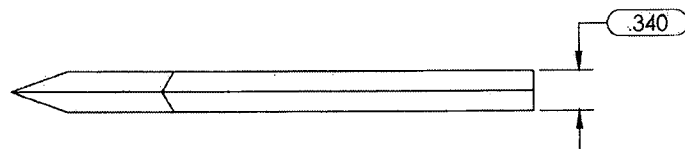


HOLE LOCATIONS +/- .002

646.9710

| | | | |
|--|--|--|-----------------|
| ORIGINAL DATE 10/2/84 | | APICAL INDUSTRIES | |
| DRAWN BY P. BLANCO | | 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 | |
| CHECKED BY P. BLANCO | | CUTTER SUB ASSY | |
| DRAWING APPROVAL P. BLANCO | | DATE 10/2/84 | REV. C |
| CONTRACT NO. | | SCALE NONE | SHEET 4 OF 6 |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5° | | CAGE CODE R 07M26 | |
| DWG. NO. 646.9700 | | | |

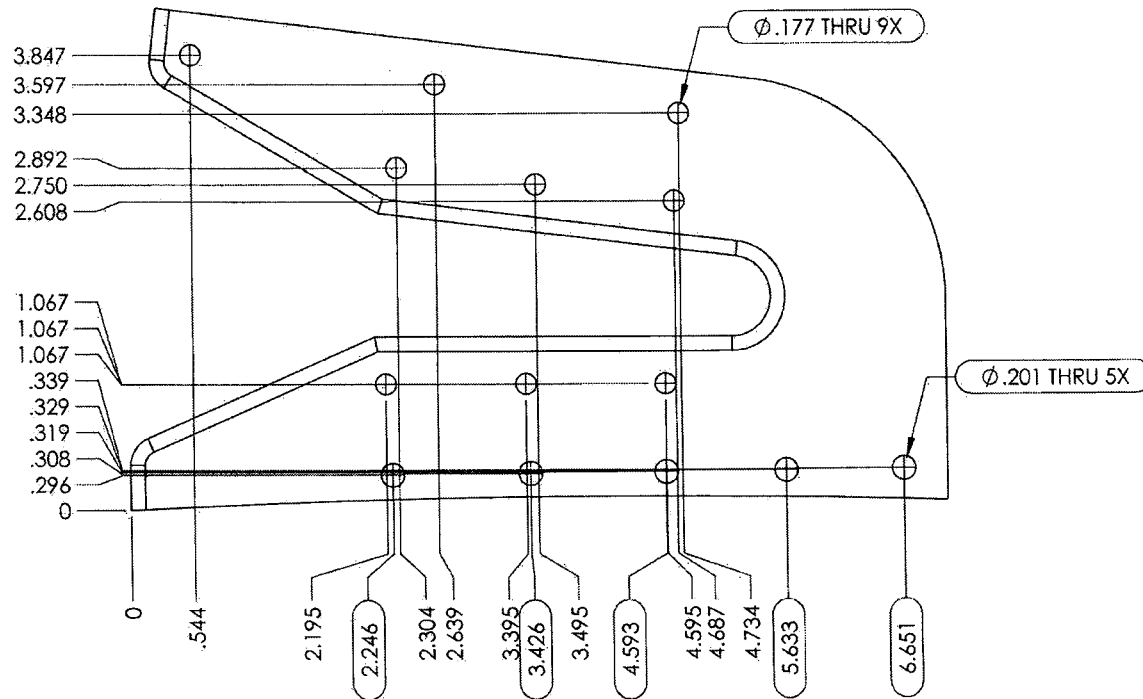
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646.9711

| | | | |
|---|-----------------|---|--------------|
| (PRELIMINARY DATE) (NO DATE) DRAWN BY: F. ROSANO CHECKED BY: P. BRAYO DRAWING APPROVAL: P. BRAYO 03/28/02 CONTRACT NO. | | APICAL INDUSTRIES 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760) 724-5300 | |
| UNITS (OTHERWISE SPECIFIED) DIMENSIONS ARE IN INCHES TOLERANCES ARE: 2 PLACE DECIMALS ± .01 3 PLACE DECIMALS ± .005 ANGLES ± .5° | | SCALE: NONE | SHEET 5 OF 6 |
| SUPP. CODE: 8 | DWG. NO.: 07M26 | PART NO.: 646.9700 | REV: C |

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646.9712

| | | | |
|--|--|--|-----------|
| ORIGINAL DATE 05/29/09 | | APICAL INDUSTRIES | |
| DRAWN BY J. POHARD | | 2608 TEMPLE HEIGHTS DR. OCEANSIDE, CA. 92056-3512 (760)724-5300 | |
| DRAWING APPROVED F. BRAYO 03/29/09 | | CUTTER SUB ASSY | |
| CONTRACT NO. | | | |
| UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES DECIMALS ARE 2 PLACE DECIMALS ±.03 ANGLES ±.5° | | SUB B | REV. C |
| SCALE: NONE | | SHEET 6 OF 6 | |